

**Work Order ID 70380**

Page 1

Monday, June 06, 2011 9:26:35 AM

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 11-06-06

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100   
 Waterjet FLOW WATER JET 0.00   
 Memo: 0.00   
 1-Cut as per Dwg D3535  Dwg Rev: B  Prog Rev: B  2-  
 Deburr if necessary   
304.040   
KB11-6-7   
8

110   
 QC2- Inspect parts off machine FAI/FAIB 0.00   
 QC Memo: 0.00   
 Quality Control   
B11-6-7

120   
 QC8- Inspect parts - second check 0.00   
 QC Memo: 0.00   
 Quality Control   
Jul 06/08   
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3535-21

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Setup Start



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Item Name: Wearshoe

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Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

8

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form bend &amp; joggle as per Dwg D3535 using DT8261 &amp; DT8326

SB 166108

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Su 166108

48

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

8:30  
0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

9:00

115128

8X Ø M-11/06/09

W/O:		WORK ORDER CHANGES					
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**Work Order ID 70380**

Page 3

Monday, June 06, 2011 9:26:35 AM

Item ID: D3535-21

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

8 d BK 11-6-9

F-P 18

170

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Packaging

Memo

0.00

8x8 M-11/06/09

W/6/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

MF 11-06-09

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

# Picklist Print

Page 1

Monday, June 06, 2011 9:26:31 AM

Work Order ID: 70380



Parent Item: D3535-21



Parent Item Name: Wearshoe

Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	266.3814	0.8925	5.636842	7.2 131-6-1		

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	266.3814	
116623	0.2	
117550	10.1814	
117933	256	117933

8

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>70380</b>
<b>Description:</b> Wearshoe	<b>Part Number:</b>	<b>D3535-21</b>
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-6-07</u>	Date: <u>11/08/08</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

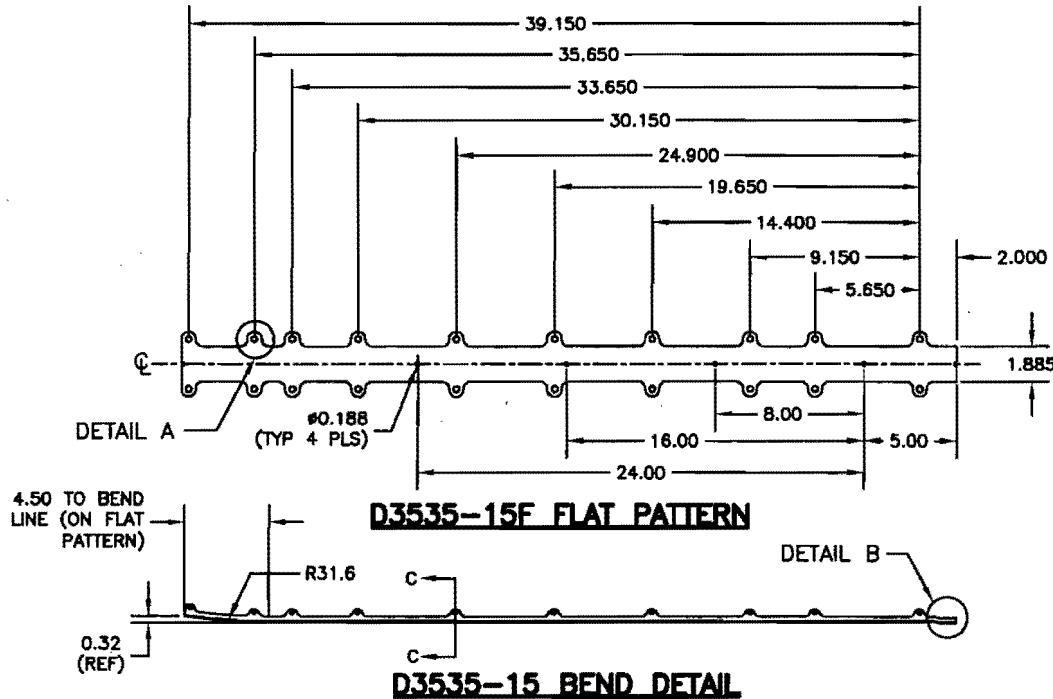
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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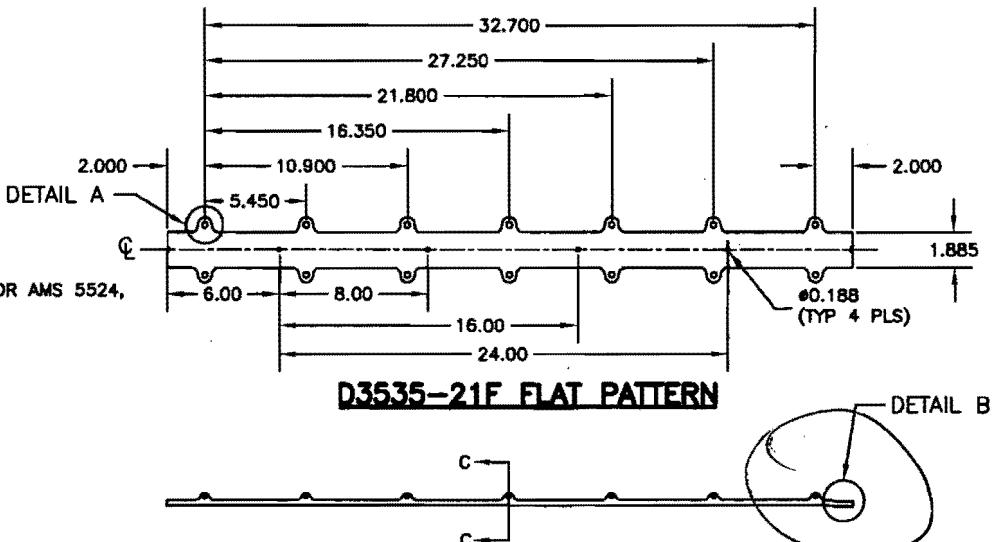
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1013

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\varnothing$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D35.35-21 BEND DETAIL

<b>DART</b>		<b>DART AEROSPACE USA, INC.</b>	
DESIGN	DRAWN BY	PORT HADLOCK, WA	
<b>CB</b>	<b>PH</b>		
CHECKED	APPROVED	DRAWING NO.	REV. B
<b>PH</b>	<b>PH</b>	D33535	SHEET 2 OF 7
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

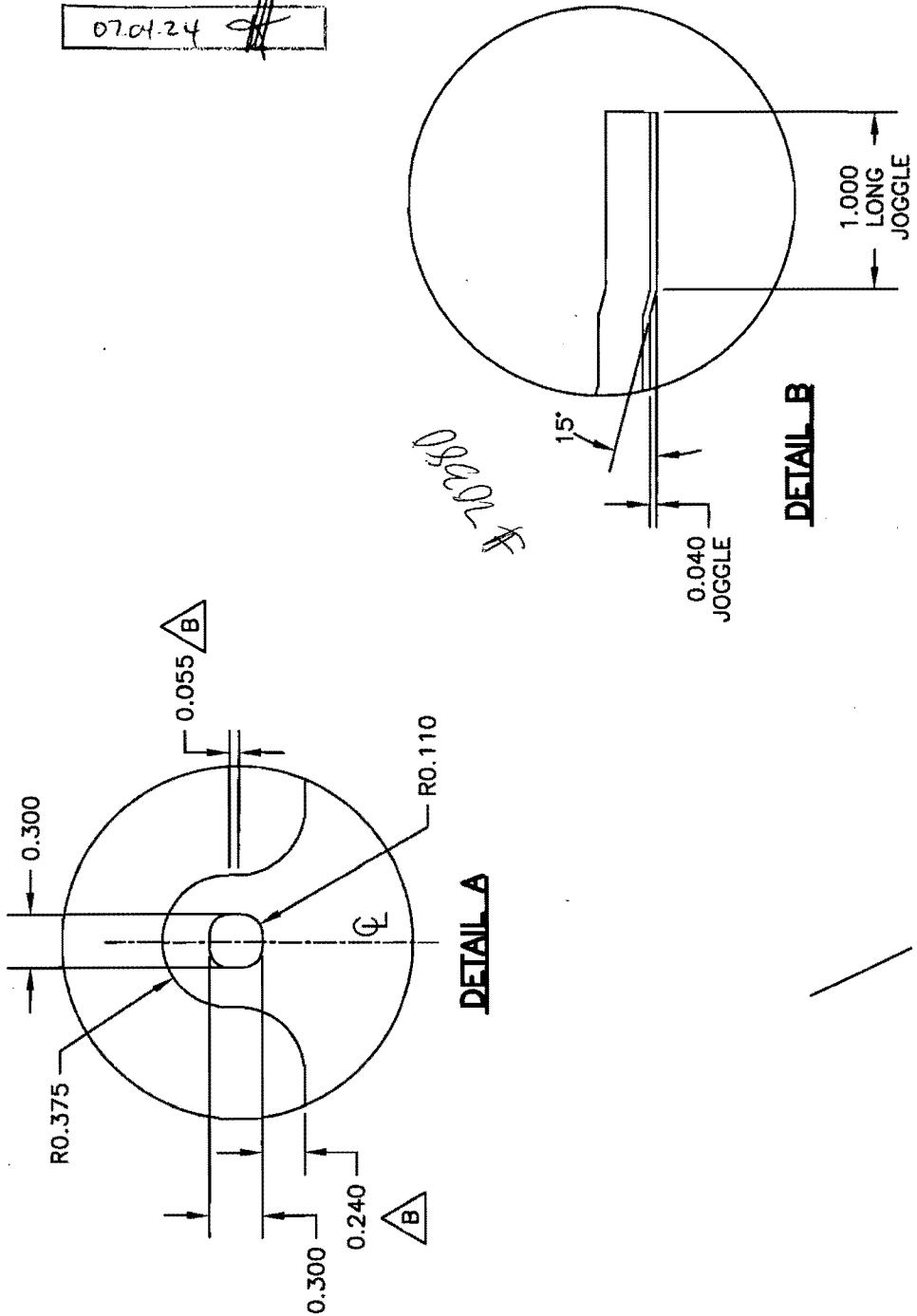
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NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24 *[Signature]*

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